

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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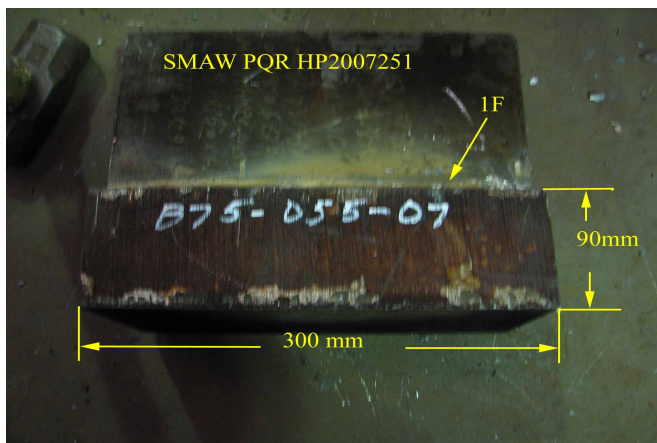
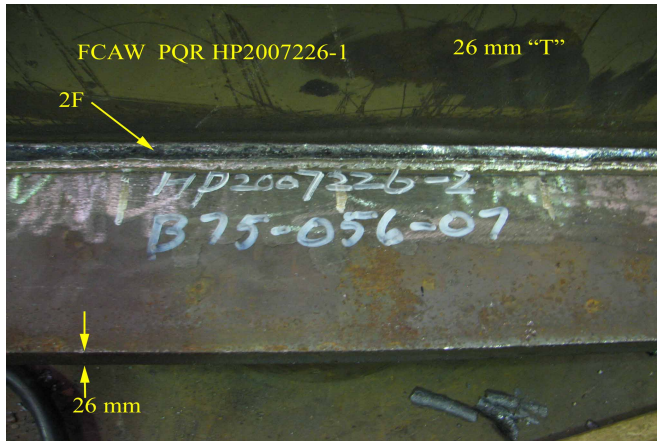
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000411**Date Inspected:** 25-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** PQR**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding being performed for Procedure Qualification Records (PQR) Number HP2007251 (SMAW), PQR HP2007257 (SMAW) and HP2007226-1 (FCAW). The welding was performed in the 1F or flat fillet position for PQR's HP2007251 and HP2007257. PQR HP2007226-1 was performed in the 2F or horizontal fillet position. All weld joints were "T" joints with an equal thickness of 90 millimeters for both SMAW PQR's and 26 millimeters for the FCAW PQR. The QA Inspector observed ZPMC CWI Huang Wei monitoring preheat, welding amperage and welding voltage. Mr. Wei was being assisted Meng Chun Xia of the ZPMC Technological Department, who was monitoring travel speed and recording all weld parameters. The QA Inspector also performed random verification of the above weld parameters and documented same. The following photograph provides additional detail.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

Mr. Wei informed the QA Inspector that he would supply copies of the data recorded by ZPMC, after lunch.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
